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**D044-717-011**  
**Job Sheet 167422**



Part No: D044-717-011

Job Qty: 4 ea

Part Name: R44 Cold Weather Baffle



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/31/17

Job Tracking No:

Due Date: 11/12/17

Created By: Victoria Michaud-Febrille

Type: Stock

Description:

Customer: Valley B Aviation (CVALL02)

PO Box 689 Manning, AB, T0H 2M0 Canada ph:(780) 836-4309 fx:(780) 836-4397.

Ship Via:

### Bill of Materials

### Job Routing

| Op No | Operation          | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off |
|-------|--------------------|-------|------------|----------|-----------|---------|-----------------------|-----------|----------|
|       |                    |       |            |          | Setup hrs | Run Hrs | Workcenter / Supplier | Lead Time |          |
| 90    | Start up Operation | 4 Ea  | 11/12/17   | 11/12/17 | 0.00      | 0.00    | Start Up Stores/Pkg1  |           |          |
| 110   | Packaging          | 4 pcs | 11/12/17   | 11/12/17 | 0.00      | 0.00    | Packaging1            |           |          |
| 120   | QC                 | 4 pcs | 11/12/17   | 11/12/17 | 0.00      | 0.00    | QC4                   |           |          |
| 125   | DC                 | 4 pcs | 11/12/17   | 11/12/17 | 0.00      | 0.00    | DC                    |           |          |
| 130   | Packaging          | 4 pcs | 11/12/17   | 11/12/17 | 0.00      | 0.00    | Packaging3            |           |          |
| 140   | QC21-FG            | 4 Ea  | 11/12/17   | 11/12/17 | 0.00      | 0.00    | QC21                  |           |          |

Part Op 110 - Pick Kit

Descriptions: 120 - QC4- 100% Inspect kits for completeness

125 - Photocopy bluefile and create labels per PPP D044-717-011CHG001

130 - Identify and pack for shipping as per PPP D044-717-011 Location: FG027

140 - QC21- Final Inspection - Work Order Release

DAS  
21  
9-69

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### Job Allocations

| Operation             | Component Part       | Required | Inventory | Allocated | Std Qty |
|-----------------------|----------------------|----------|-----------|-----------|---------|
| 90-Start up Operation | AN526C1032R7 5008141 | 82       | 106       | 0         | 0       |
|                       | D3276-041 110736     | 4        | 4         | 0         | 0       |
|                       | D3276-042 110812     | 4        | 5         | 0         | 0       |
|                       | D3383-1 5008105      | 4        | 9         | 0         | 0       |
|                       | MS20426AD3-4 5008096 | 64       | 6,964     | 0         | 0       |
|                       | MS21059L3 5008087    | 32       | 126       | 0         | 0       |

### Part Specifications

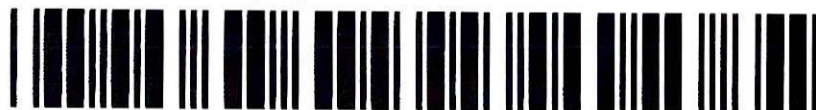
Specifications could not be found.

Plex 11/9/17 7:20 AM dart.lacelle.linda

**DART**  
AEROSPACE  
**S008163**

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**R44 Cold Weather Baffle**

**PART NO: D044-717-011**

**Revision:**

**Operation: Start up Operation**

**Change No:**

**Mfg Date: 11/09/17**

**Job No: 167422**

## 2.0 GENERAL NOTES

### COMPATIBILITY

Compatibility of this installation with the aircraft is the **responsibility of the installer**. Ensure that this installation does not conflict with a previous modification.

### CONTINUING AIRWORTHINESS

These installations should be maintained in accordance with the Instructions for Continued Airworthiness ICA-D044-717. Refer to the Aircraft Maintenance Manual for standard shop practices not referred to in these Installation Instructions.

## 3.0 INSTALLATION PROCEDURE

The Dart D044-717-011 Cold Weather Baffle Kit should be installed as follows:

- 3.1 Temporarily locate the D3276-041 Baffle Assembly on the LH inlet as shown in Figure 1. Transfer drill the 4 holes to the aircraft and enlarge to  $\varnothing 0.203$ " (5.20mm). Ensure minimum edge distance of 0.300" from center of hole to edge of opening.
- 3.2 Drill  $\varnothing 0.098$ " holes for MS20426AD3-4 rivets that will be used to install the MS21059L3 nutplates. C'sink  $\varnothing 0.179$ "x100° (4.55mm x100°).
- 3.3 Deburr all drilled/c'sink holes and touch-up with primer per the Aircraft Maintenance Manual.
- 3.4 Install MS21059L3 nutplates on a/c holes using MS20426AD3-4 rivets. Install the D3276-041 Baffle Assembly using AN526C1032-7 screws. Torque screws 15-25 in-lb (2-3 Nm)
- 3.5 Repeat installation for RH side using D3276-042 Baffle Assembly.
- 3.6 Install D3383-1 Placard in full view of the pilot.

## 4.0 WEIGHT AND BALANCE

The following is the net weight increase associated with the installation.

| Installation            | Weight  | LATERAL |        | LONGITUDINAL |           |
|-------------------------|---------|---------|--------|--------------|-----------|
|                         |         | Arm     | Moment | Arm          | Moment    |
| D044-717-011            | 0.86 lb | 0       | 0      | 160 in       | 138 in-lb |
| Cold Weather Baffle Kit | 0.39 kg | 0       | 0      | 4.06 m       | 1.6 m-kg  |

## 5.0 PARTS LIST

| Qty<br>-011 | Part Number  | Description             |
|-------------|--------------|-------------------------|
| X           | D044-717-011 | COLD WEATHER BAFFLE KIT |
| 1           | D3276-041    | BAFFLE ASSEMBLY, LH     |
| 1           | D3276-042    | BAFFLE ASSEMBLY, RH     |
| 1           | D3383-1      | PLACARD                 |
| 8           | AN526C1032-7 | SCREW                   |
| 16          | MS20426AD3-4 | RIVET                   |
| 8           | MS21059L3    | NUTPLATE                |